

Work Order ID 53941

November 23, 2009 2:33:20 PM

Page 1

Item ID: D4013-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Cup

Start Date: 11/23/2009 Start Qty: 80.00

Cust Item ID:

Required Date: 11/27/2009 Req'd Qty: 80.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: mf

Date: 09-11-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4013

C

100

0.00



Doosan

Doosan Lathe

Memo

turn as per Dwg

Dwg Rev: 2

Deburr

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

mf 09.11.30 / JL 09/12/03

mf 09.11.30 / JL 09/12/03

DT 09/12/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID:

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Item Name: Cup

Start Date: 11/23/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 11/27/2009 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: *W/A*

0.00

Memo

EL

0.00

Packaging

*9-12-7**(86)*

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*09/12/07**mf**09-12-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53941



Parent Item: D4013-5



Parent Item Name: Cup

Start Date: 11/23/2009

Required Date: 11/27/2009

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
revC as per dwg 09.11.18 DD verified by:JLM

IPP RevC:

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	49.4000	12.6316			



304 SS Roundbar .750



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

49.4

113216

49.4

09.11.30

2' +

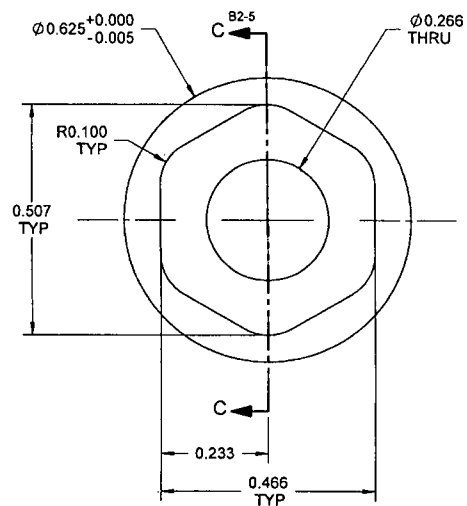
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

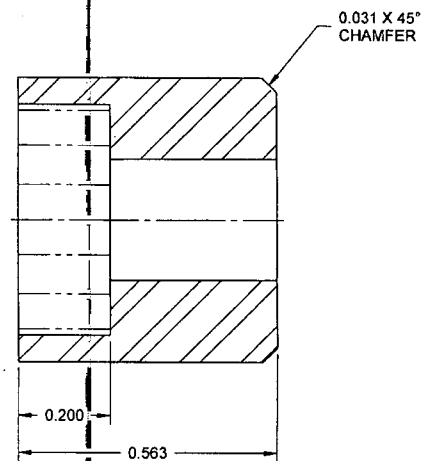
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4013-5 CUP



SECTION C-C D6-5

RELEASED
2009-11-24
MD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs EACH

DESIGN	LA	DART AEROSPACE LTD	
DRAWN	LA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4013	SHEET 5 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEARPLATE ASSEMBLY	NTS
DATE	09.11.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	